

Date: Friday, 19/12/2008 8:32:53 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number : 44192	
Estimate Number : 10257	
P.O. Number :	Part Number : D212664201
This Issue : 19/12/2008 S.O. No. :	Drawing Number : D212-664-241 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : CROSSTUBES	Drawing Revision : C
Previous Run : 44138	Material :
Written By :	Due Date : 09/01/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JD 08.12.19</u>	
Comment : : Est Rev:E 04.02.16 Reformat K/DS : Est Rev:F 06-03-29 Remove Coments on Pick List JLM : Est Rev:G 07-04-30 As per Rev C JLM : Est Rev:H 08-05-22 up date Qty of rubber cushion DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



for JD 09/01/21

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

5 09/01/21

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

3.0	D212664201TRN	Crosstube Turning Detail
-----	---------------	--------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *B-44155*

MB 09-01-14

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------

**Comment:** BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

DP 9-1-14

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------

**Comment:** DIMENSIONAL CHECK OF X-TUBES

5 09/01/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

MB
09-01-15

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1, within 24 hours of bending and drilling

MB 09-01-15

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/01/15 (X)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/15 (X)

10.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 8000

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

u 09.01.19

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

09/01/19 (1)

W/O:		WORK ORDER CHANGES						
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Job Number: 44192

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



ml 09/01/19



(1)

Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 09 01 19 (1)

14.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

RT 09-01-20

15.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support 40753

RT 09-01-20

16.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rubber Cushion

Batch: 39255

RT 09-01-20

17.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp 109181

RT 09-01-20

W/O:		WORK ORDER CHANGES						
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Job Number: 44192

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 109900

Expiry Date: 09-08-01

09-01-20

3-Install clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

09-01-21 ①

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-01-21 ①

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Placard

Batch: B42448

22.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M108940

23.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M107013

09-01-21 ①

W/O:		WORK ORDER CHANGES						
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Job Number: 44192

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: 111002

25.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

Batch: 19099

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-22

B44192 D212-664-201

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

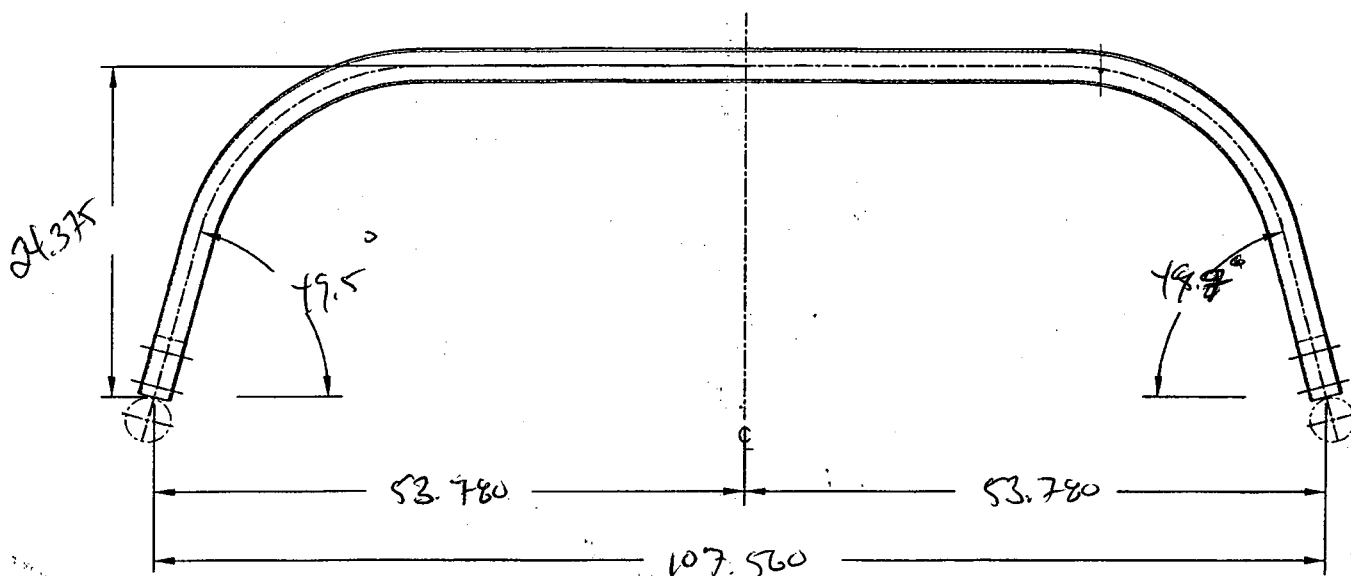
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DART AEROSPACE LTD		Work Order:	44192
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	S
Date	07/05/08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED
07.04.24 *q*
PER E.I.N. 025

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
NOTE: MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
64192

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W/O:		WORK ORDER CHANGES						
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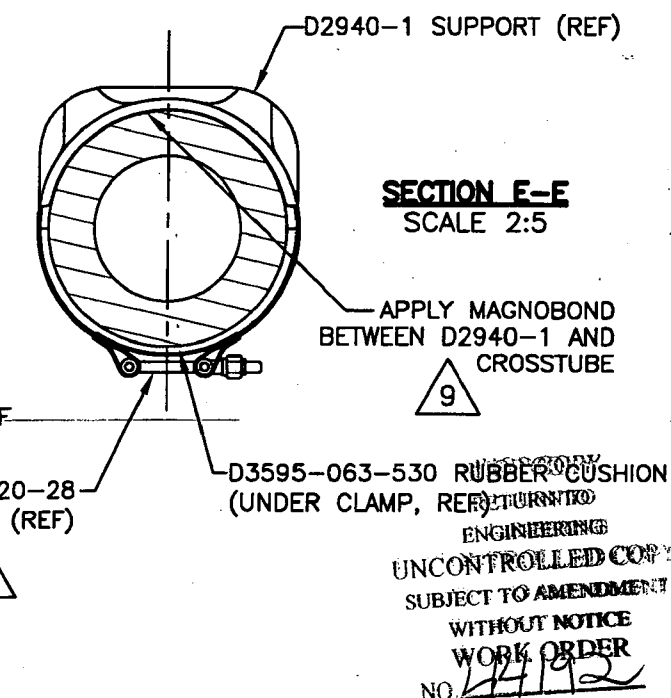
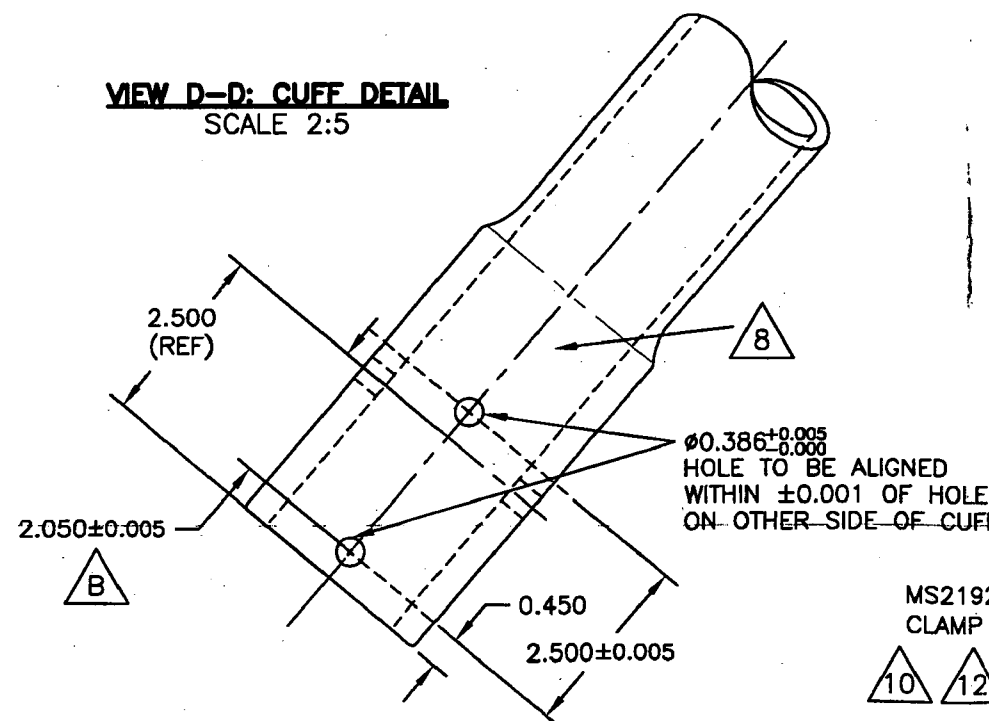
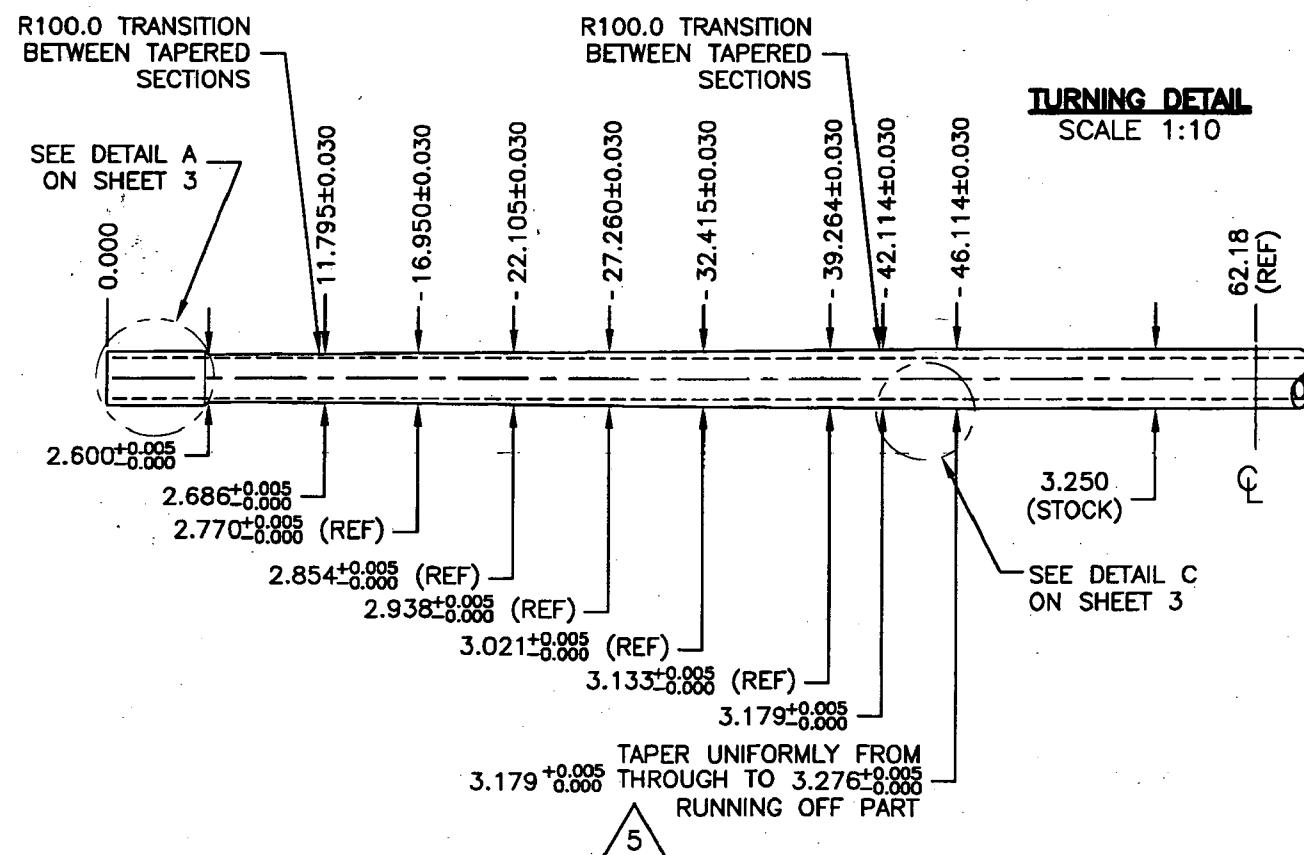
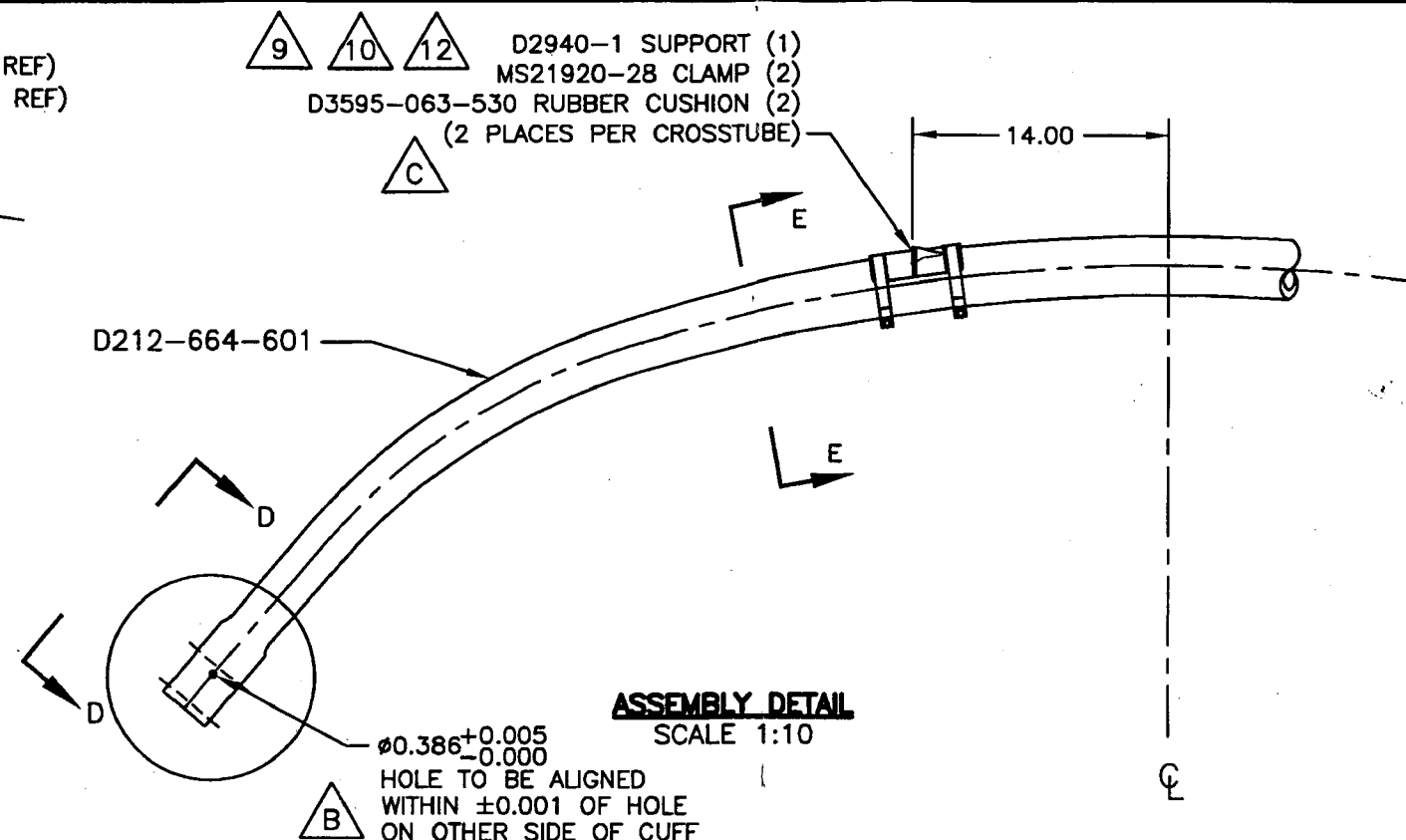
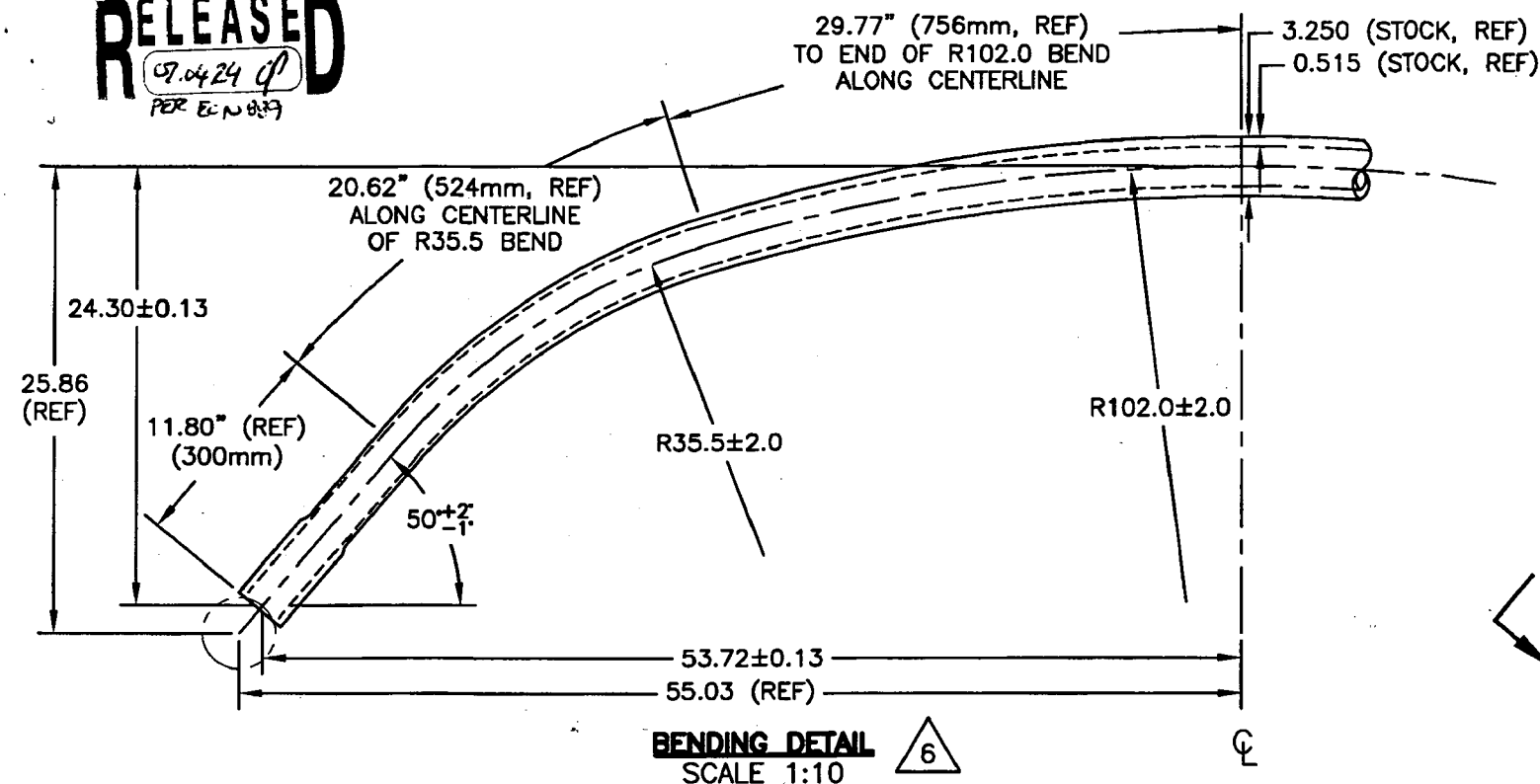
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NOTE: Date & initial all entries

RELEASED
07.04.24
PER E-10.039



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DESIGN

PH

DRAWN BY

PH

CHECKED

APPROVED

DATE

07.03.08

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D212-664-241

TITLE

CROSSTUBE ASS'Y (205/212 HI AFT)

REV. C

SHEET 2 OF 3

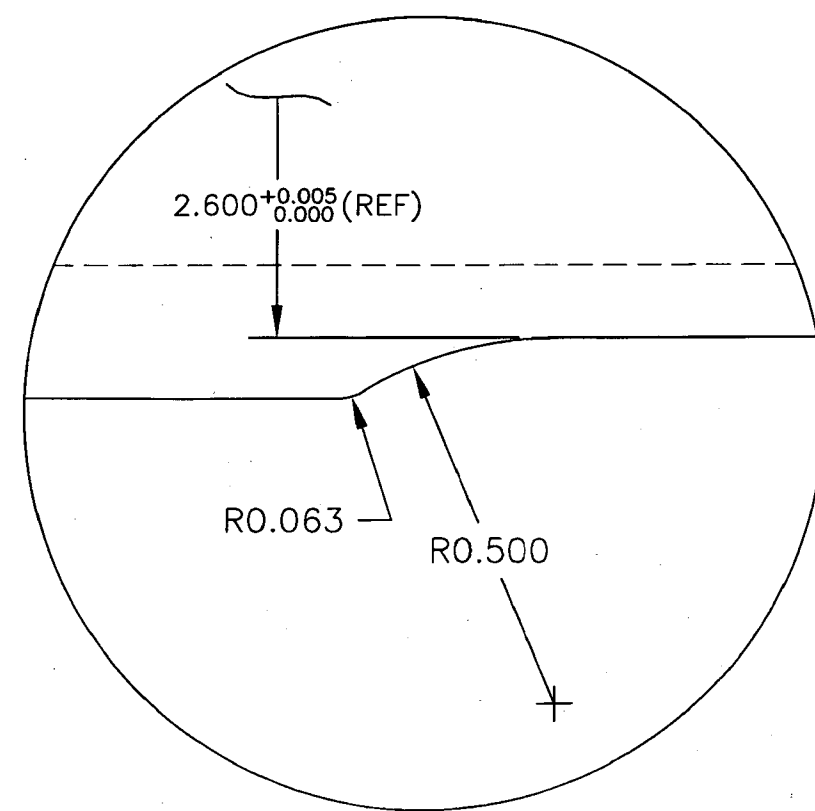
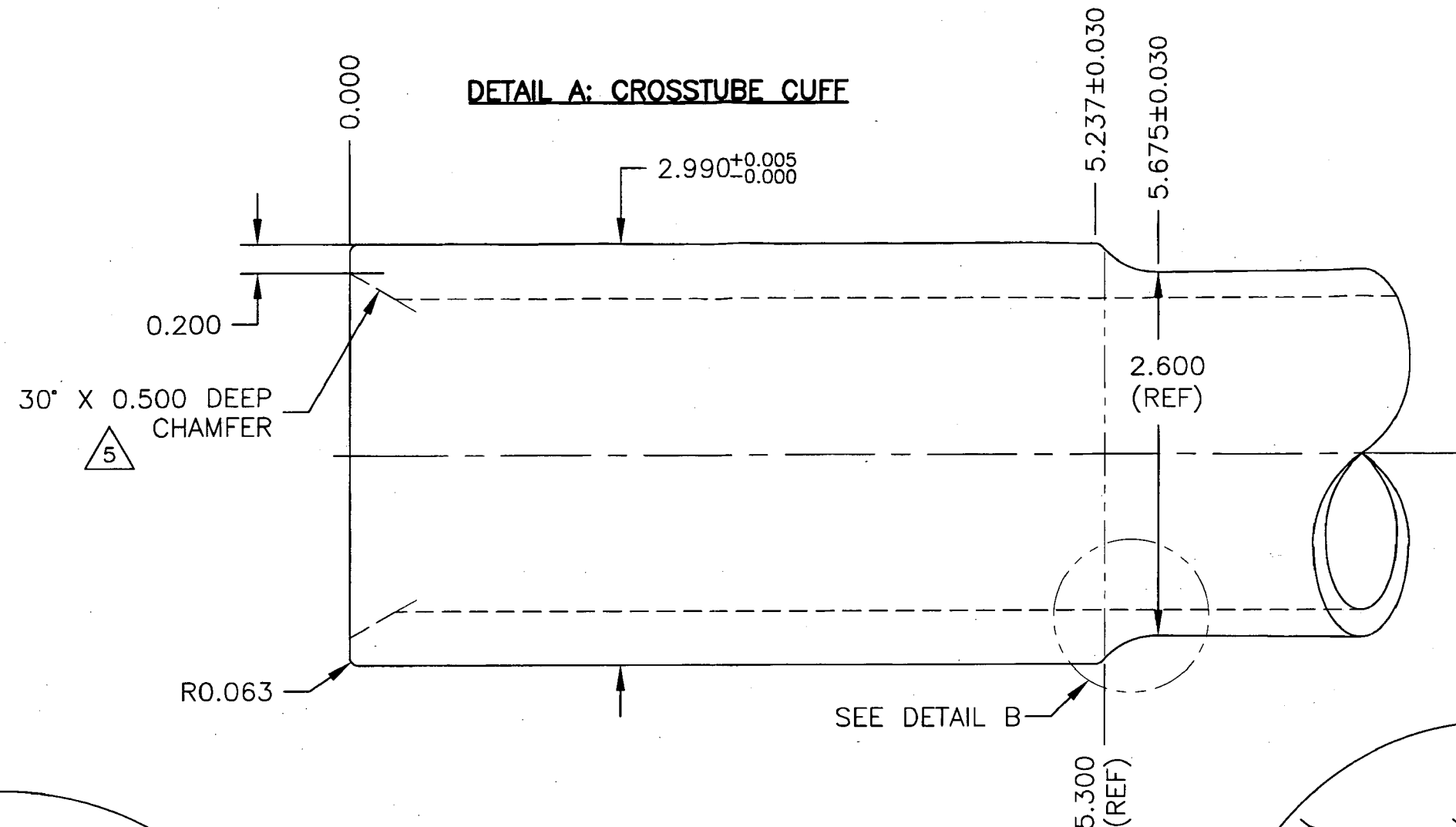
SCALE

1:10

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24192

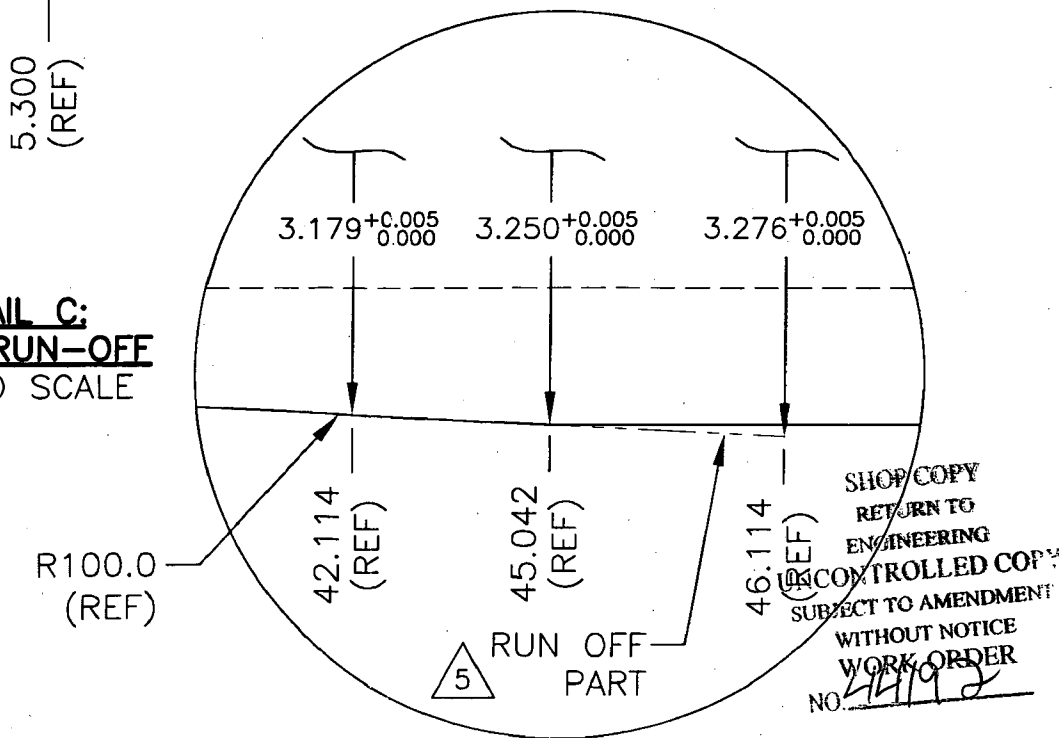
RELEASED
07.04.24 P
PER ECN 889

DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DATE		07.03.08		DRAWING NO.	REV. C
				D212-664-241	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE ASS'Y (205/212 HI AFT)	1:1



LIQUID PENETRANT TEST REPORT

P- 149

PAGE 1 OF

CLIENT DART AEROSPACE DATE JAN 16-2009 TIME AM ☐ PM
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-09-001278
ADDRESS 1270 ABERDEEN ST POWO No. 8000
HAWKES BURY ONT WORK LOCATION MAIN SHOP-HAWKES
ACCEPTANCE STD. ASTM1417 REV./DATE 200
PROJECT X-TUBES QSI-038
ITEM(S) EXAMINED 7 ITEMS. FLOUORESCENT DIE

JOB DESCRIPTION PROCEDURE No. LT-XXXX REV./DATE TECHNIQUE No. LT-XXXX-XXX REV./DATE

PART NO. MATERIAL ALODINED ALUM. THICKNESS
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EM
FAMILY BRAND MACNAFLUX BLACK LIGHT S/N 8171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT
PENETRANT ZLO7 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER
DEVELOPER SK052 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE FES
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE ME
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)
PART IDENTIFICATION
1 - B-44125-443052 SC 1 44215
1 - B-44156-44193 ✓
1 - B-44155-44192 ✓
1 - B-44378-44139 ✓
1 - B-44379-44140 ✓
1 - B-43330-44384 ✓
1 - B-43051-44214 ✓
NO INDICATION WAS LOCATED ON THIS PIECE. WILL BE SANDED TO S.F.M., AND REEXAMINED AT LATER DATE
09 01 19

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Julie Dawson SIGNATURE Julie Dawson DTR # 19804
TECHNICIAN (SIGNATURE): Mike Johnston
NAME (PRINT): Mike Johnston 1ST TECHNICIAN
CGSB LEVEL II SNT LEVEL II CGSB LEVEL II SNT LEVEL II
CGSB REG. NO. 0666 CGSB REG. NO. 0666 2ND TECHNICIAN
REPORT REVIEWED BY: NAME INIT



Client: DART AEROSPACE
Contact: LINDA LACELLE
Location: 1270 ABERDEEN
Description: X-TUBES 7 PCS.
Report #s: F. LPI

E- 19804

Form dated Sep 2005

Job #: 188-04-001278
Day: Sun Mon Tues
P.O. #: _____
Vehicle # 579

Date: JAN-16-2009
 Wed Thurs Fri Sat
 W.O #: 108-09-001278
 Camera #:

[illegible]

RADIOGRAPHIC UNIT PRICING																					
Weld Diameter												Long Seam					Circ. Seam				
Schedule / Thickness												Thickness					Thickness				
Quantity												Lineal Ft.					Lineal Ft.				

Film: _____ Pcs. 2 3/4 x 17"

_____ Pcs. 3 1/2 x 17"

_____ Pcs. 4 1/2 x 17"

_____ Pcs. 14" x 17"

_____ Pcs.

Consumables:

Equipment:

Client Representative:

WET FLUORESCENT.
AS PCL -

Place a check mark in each safety check area as completed	
C/C	CAMERA CHECK
S/E	SAFETY EQUIPMENT CHECK
S/C	SURVEY METER CHECK
B/S	BARRRIER & SIGN INSTALLED
C/L	CAMERA LOCKED & SECURELY STORED
C/S	CAMERA SURVEYED AFTER EACH USE

EXPENSES

NOTES

ACUREN 1-877-299-2857

Oakville	(905) 825-8595 • Fax (905) 825-8598
Sarnia	(519) 336-3021 • Fax: (519) 336-8220
Sudbury	(705) 522-1849 • Fax (705) 522-9926
Halifax	(902) 497-3870 • Fax (902) 445-5090
North Bay	(705) 840-8107 • Fax (705) 476-6683
Val D'Or	(819) 856-6789 • Fax (819) 825-9564

Cambridge	(519) 622-3112 • Fax (519) 622-1326
Cornwall	(613) 931-1261 • Fax (613) 931-2777
Saint John	(506) 847-0194 • Fax (506) 847-0194
Thunder Bay	(807) 475-4240 • Fax (807) 577-2017
Gaspé	(418) 392-3618 • Fax (418) 392-4114
Hull	(819) 360-0685 • Fax (819) 827-3513